

Work Order ID 83910

83910

Page 1

Tuesday, May 29, 2012 11:23:56 AM

Item ID: D3564-11

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Wearshoe

Stop *NS2*

Start Date: 4/27/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 5/4/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan: *MF*

Date: *12-05-09* Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ***** (D3564-1F) ***** Dwg Rev: *D* Prog
Rev: *D* 2-Deburr if necessary

B12-5-2

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-5-2

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

8/2/10/04

cauts
102

Work Order ID 83910

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Page 2

Tuesday, May 29, 2012 11:23:56 AM

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Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Wearshoe

Stop

NS2

Start Date: 4/27/2012 Start Qty: 16.00

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Cust Item ID:

Required Date: 5/4/2012 Req'd Qty: 16.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Brake NC

Brake NC

NC BRAKE

Memo

0.00

0.00

Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179

22

12/05/09

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/20/09

cont
22

150

150

Large Fab

Large Fab

Large Fab

Memo

0.00

0.00

Qty Description

Batch A/R

2059B Hardcoat

m 12/1802 Weld hardcoat as per Dwg D3437

22

ME

12-05-29

Work Order ID 83910

83910

Page 3

Tuesday, May 29, 2012 11:23:56 AM

Item ID: D3564-11 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearshoe
 Start Date: 4/27/2012 Start Qty: 16.00 *16* Cust Item ID:
 Required Date: 5/4/2012 Req'd Qty: 16.00 *16* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC10- Inspect visual per QSI004- ground welds 0.00

160

QC

Memo

0.00

Quality Control

170 QC5- Inspect part completeness to step on W/O 0.00

170

QC

Memo

0.00

Quality Control

180 Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 0.00

180

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3200F

12:15

M121279

cate
 (P20)

22X ✓

M/L
 12/25/30

Work Order ID 83910

Tuesday, May 29, 2012 11:23:56 AM

83910

Page 4

Item ID: D3564-11

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Wearshoe

Stop ***NS2***

Start Date: 4/27/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 5/4/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

22x ✓ 12/05/30

200

Identify as per dwg & Stock Location: FPI

0.00

200

Packaging

Memo

0.00

Packaging

22x ✓ M-L 12/05/30

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

12/5/30 ✓

MLJ 12/05/31

Picklist Print

April-27-12 11:18:11 AM

Page 1

Work Order ID: 83910

83910

Parent Item: D3564-11

D3564-11

Parent Item Name: Wearshoe

Start Date: 27/04/2012

Required Date: 04/05/2012

Start Qty: 16.00

Required Qty: 16.00

Comments:

IPP Rev: A New Issue 07-03-08 cc
IPP Rev: B As per Rev C 07-07-09 JLM
IPP Rev: C As per Rev D 07-09-09 JLM Verified By: EC
IPP Rev: D Comments revised on Step 5, 6 per B44656 09-02-06 KJ
Verified By:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	116.8720	1.41	23.74737	31.		

M304S16GA

304/316 Sheet .063

**

B12-5-2

Location

Loc Qty

Loc Code

MAT020

116.872

120866

16.246

120877

100.626

120877

23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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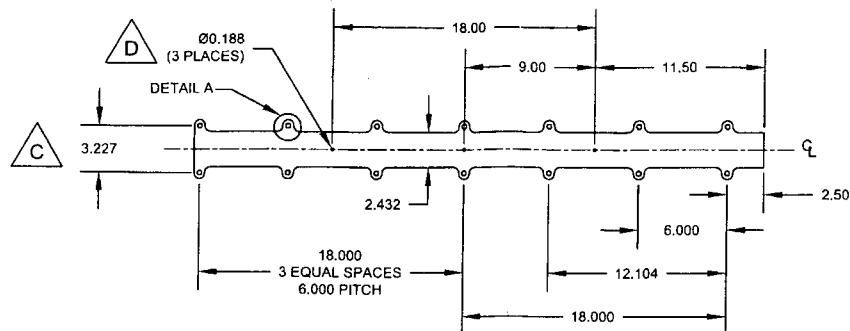
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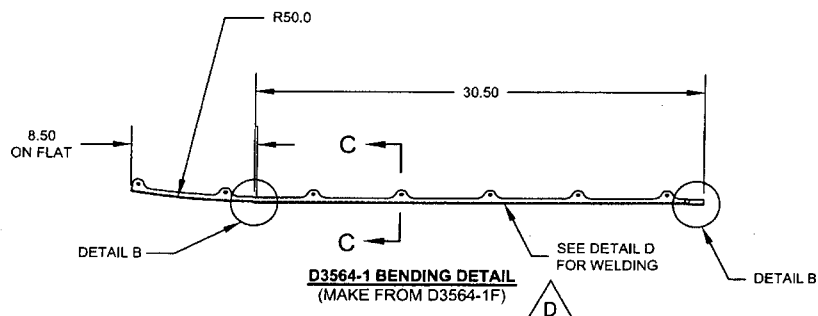
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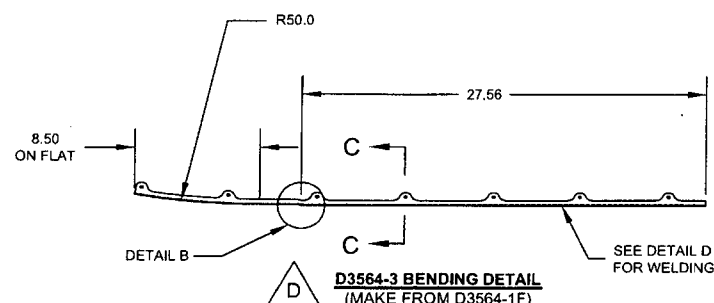
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D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

#83910

RELEASED
07.09.04

UNDER REVIEW
11/10/04
First change
OK 11.11.28

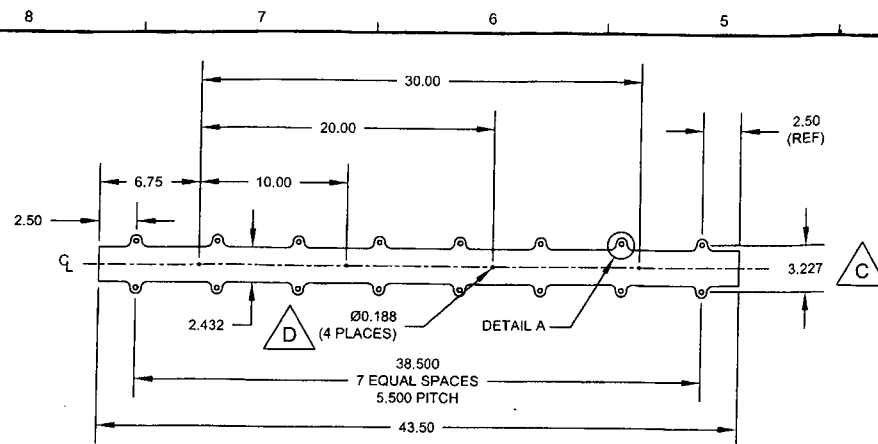
D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

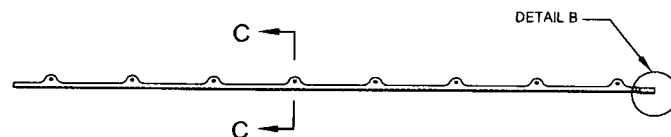
WEIGHTS:

D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

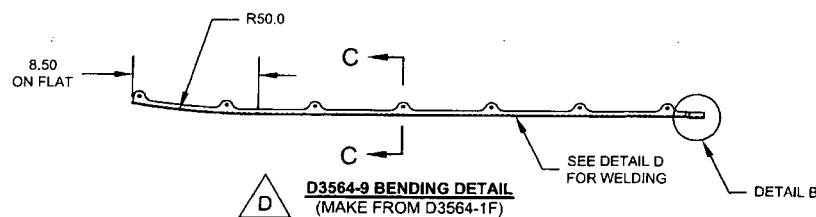
D	UPDATE DRAWING TEMPLATE: CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5, C5: ADD D3564-15; PG1 B6, B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ON PG1; PG3 B8, C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5, 7, B2: RELOCATE DETAILS AND SECTION; PG3 A5, 7, B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3564 REVISION SHEET 1 OF 3 TITLE WEARSHOE SCALE 1:8 COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



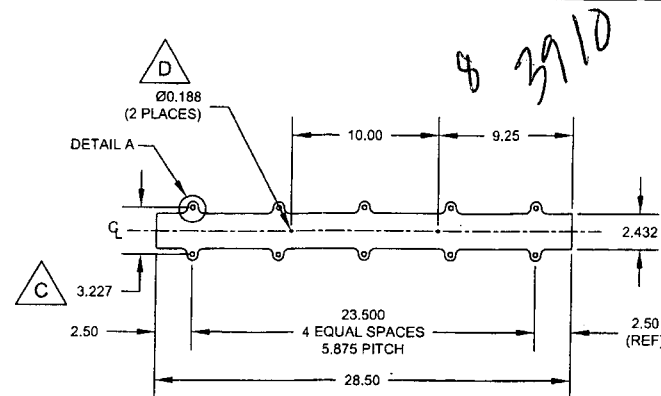
D3564-5F FLAT PATTERN



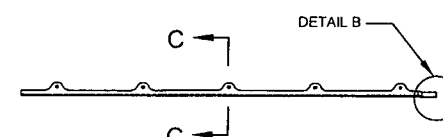
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



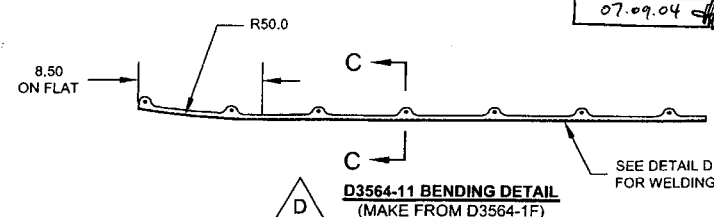
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)

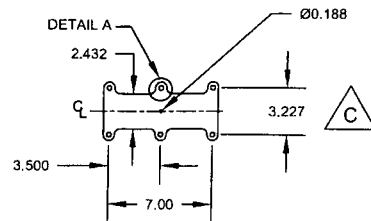


D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

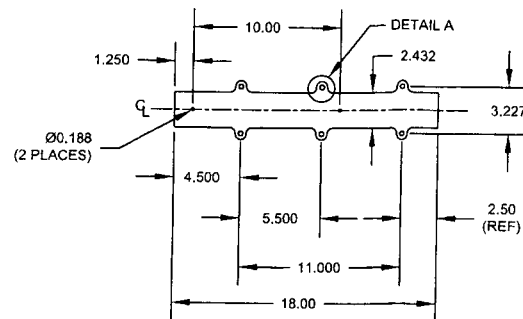
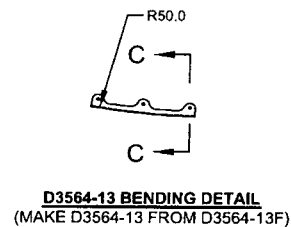
UNDER REVIEW
OK 07.11.25

RELEASED
07.09.04

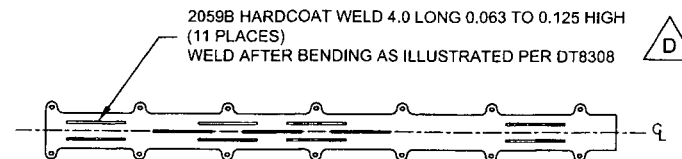
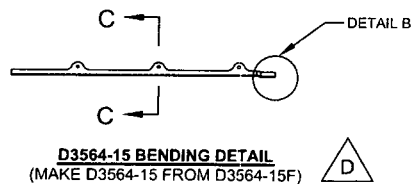
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO. D3564	REV. D
MFG. APPR.	PH	SHEET 2 OF 3	
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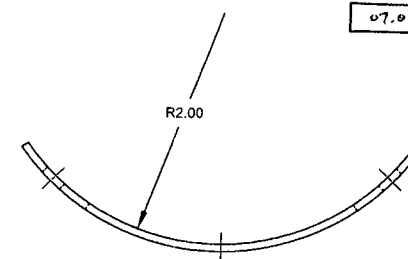
D3564-13F FLAT PATTERN



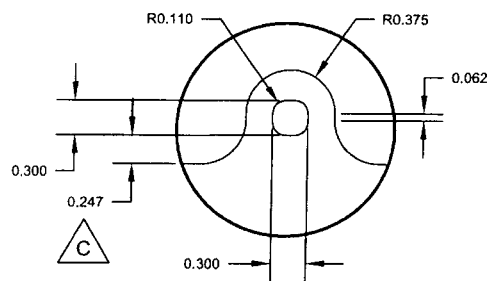
D3564-15F FLAT PATTERN



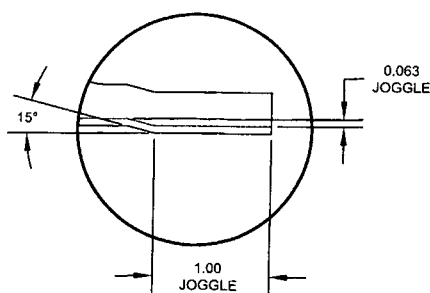
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

RELEASED

07.09.04

UNDER REVIEW
OK 07.11.28

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CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
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